

Date: Friday, 13/02/2009 1:02:27 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STA 129 BRACKET		
Job Number	: 45789		Part Number	: D29902		
Estimate Number	: 11643		Drawing Number	: D2990 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 13/02/2009	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 20/02/2009		
Previous Run	: 33602		Qty:	8		
Written By	:		Um:	Each		
Checked & Approved By	<u>JUD 09.02.13</u>					
Comment	: Est. A01.31.01 New Issue EC est B 07.08.03 waterjet blank EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X12000	6061-T6 Bar .500 x 12.00	
		Comment: Qty.: 0.9913 f(s)/Unit Total : 3.9652 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50" Batch: 109253 RB 9-2-18	(8)
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per template DT8547 ****(run prog. DT8547)**** Dwg Rev: BLANKS Prog Rev: BLANKS RB 9-2-18	(8)
		2-Deburr if necessary	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA107	JF/DTP 09/02/20 (7)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JF/DTP 09/02/21 (7)
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	88 09/02/23 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2990-2 PAR #: N/A Fault Category: Prod Eng. Cardinate NCR Yes No DQA: Date: 09/02/25
 Resolution: D2990-042 D412-630-012 Disposition: SCRAP QA: N/C Closed: Date: 09/02/25

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/20	3.0	1 st part is Scrap, 0.757" Ø is at 0.813" (0.051" over tol.) and prog #6000 had to be revised because of origins problems R.c. program error.	<u>09/02/20</u>	Scrap = No Replace. Update program	<u>09/02/20</u> <u>JULY</u> <u>Gull</u>	<u>09/02/23</u>	<u>09/02/23</u>	<u>09/02/23</u>

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

INSPECT WORK TO CURRENT STEP

7.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/02/23

9.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST151

AS 09/02/23 AF

10.0 QC21



FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	HS789
Description: STA 129 Bracket	Part Number:	D2990-2
Inspection Dwg: D2990	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	DJP	Audited by:	88	Prototype Approval:	N/A
Date:	09/02/20	Date:	09/02/23	Date:	N/A

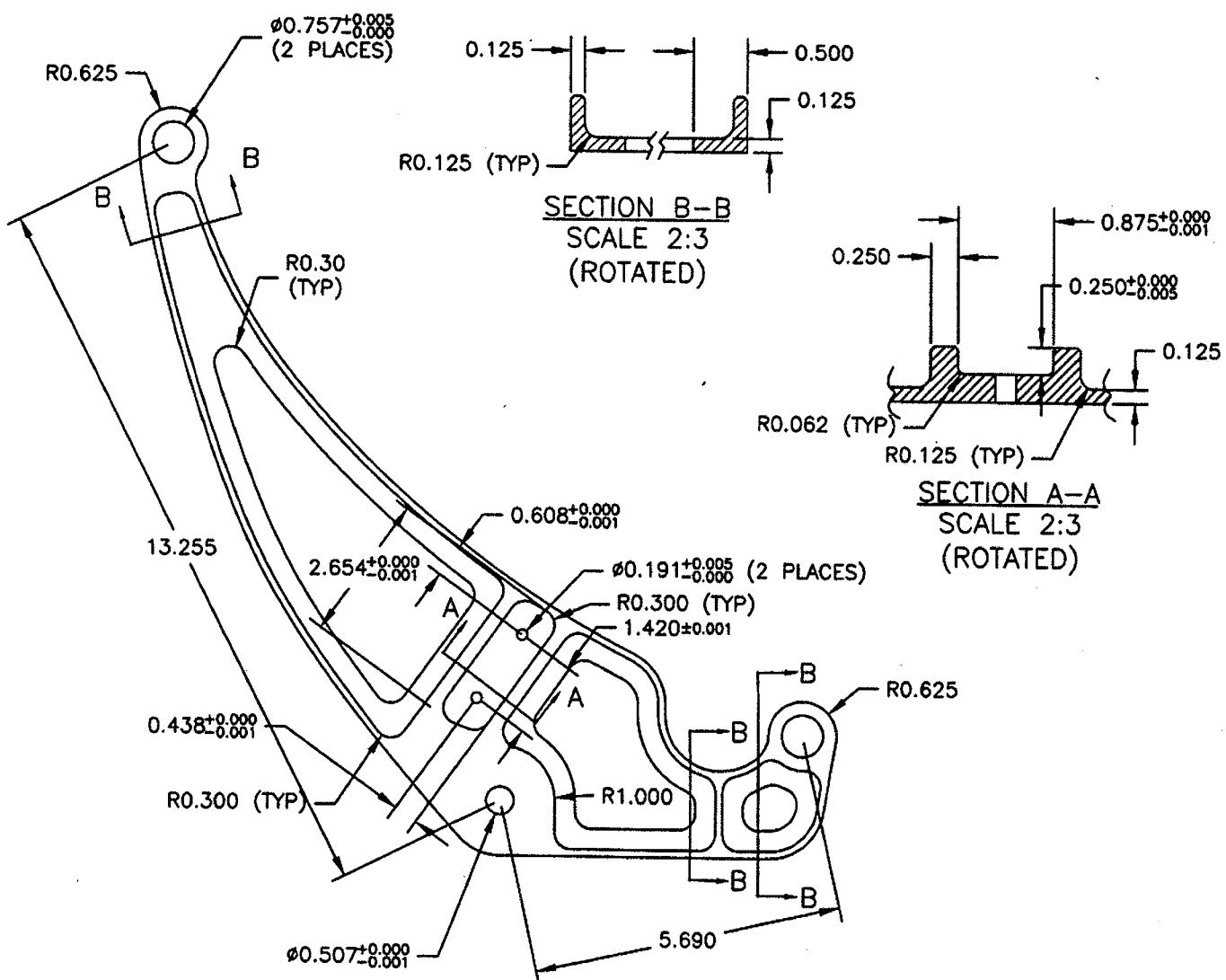
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	06.03.08	Dwg Rev. change	KJ/JLM	SJL



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>MM</i>	APPROVED <i>ff</i>	DRAWING NO. D2990	REV. B	SHEET 1 OF 2
DATE 05.01.20		TITLE STA 129 BRACKET	SCALE 1:3	
A	00.11.07	NEW ISSUE		
B	05.01.20	ADD CUTOUTS & -043/-044		

RELEASED

05.03.11 off



D2990-1 BRACKET (SHOWN), D2990-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2990.SLDPRT"
 - 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
 - 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
 - 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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EFFECT TO AMENDMENT

WITHOUT NOIRE

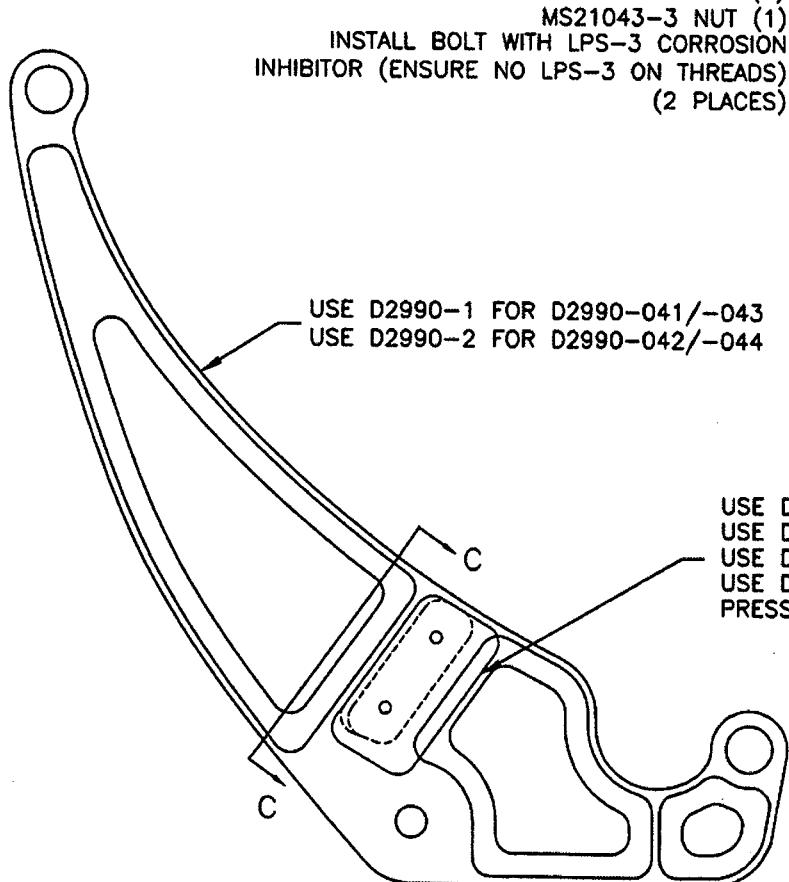
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NO. 1075

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2990	REV. B SHEET 2 OF 2
DATE 05.01.21		TITLE STA 129 BRACKET	SCALE 1:3

RELEASED05.03.11 *[initials]*

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WORK ORDER
NO. 45789

D2990-041/-043 BRACKET ASS'Y (SHOWN),
D2990-042/-044 BRACKET ASS'Y (OPPOSITE)

- 6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3